

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	X-TUBE EXTRUSION				
Job Number	:	34688							
Estimate Number	:	11108							
P.O. Number	:	N/A	Part Number	:	D6008180 ✓				
This Issue	:	9/14/2007	S.O. No.	:	N/A	Drawing Number	:	D6008 REV A	
Prsht Rev.	:	NC				Project Number	:	N/A	
First Issue	:	N/A	Type	:	LANDING GEAR	Drawing Revision	:	A	
Previous Run	:	25667				Material	:	N/A	
Written By	:	<u>[Signature]</u>	Due Date	:	1/30/2008	Qty:		7	Um: Each
Checked & Approved By	:	<u>[Signature]</u>							
Comment	:	Est Rev: C 04.06.15 Added tolerance to Step 2 KJ/JLM							

Job Number:



Seq. #:	Machine Or Operation:	Description :
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10 PG PURCHASING



Issue P/O: 4611

CL07/09/18 (7)

- a) Order as per Dwg D6008
- b) Material: 3.250 x 0.438 wall 7075-T6/T6511 (WW-T-700/7 or QQ-A-225/9 or QQ-A-200/11) seamless aluminum tube
- c) Minimum ultimate tensile strength = 77 ksi
- d) Minimum tensile yield strength = 66 ksi
- e) Tolerance are per ASTM B210 (see details on Dwg D6008)
- f) Material certification required

20	D6008180P	Crosstube extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 7.0000 Each(s)
Crosstube extrusion

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
Ensure material certification is attached

8/1/03 (8)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6005

isolaly x8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 2010/15
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/14/2007 2:01:57 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE EXTRUSION

Job Number: 34688

Part Number: D6008180

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

EL/JD 8-1-14

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

W 08.01.15 (8)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

EL 8-1-15

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

W 08.01.15 (8)

Job Completion



W 08.01.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

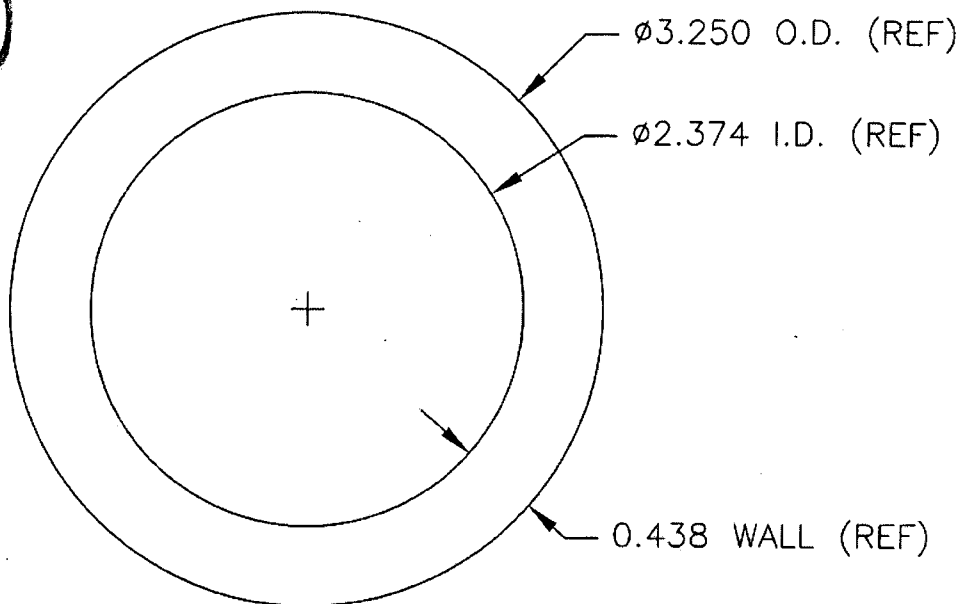
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D6008	REV. A SHEET 1 OF 1
DATE 00.11.17		TITLE CROSSTUBE MATERIAL	SCALE 1:1
A	00.11.17	NEW ISSUE	

SPECIFICATION CONTROL DRAWING

RELEASED
00.11.24 *[Signature]*



NOTES

- 1) D6008-XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 180" LONG TUBE: D6008-180

- 2) MATERIAL: 3.250 OD x 0.438 WALL 7075-T6/T6511 (WW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11) SEAMLESS ALUMINUM TUBE.
MINIMUM ULTIMATE TENSILE STRENGTH = 77 ksi
MINIMUM YIELD TENSILE STRENGTH = 66 ksi
- 3) TOLERANCES ARE PER ASTM B210 AS FOLLOWS:
O.D.: ± 0.008 MEAN (± 0.016 INCLUDING OVALITY)
WALL: ± 0.020 MEAN (± 0.044 INCLUDING ECCENTRICITY)
LENGTH: XXX $+0.125/-0.000$
STRAIGHTNESS: 0.010" DEVIATION / 12" LENGTH

- 4) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 5) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

SHOP COPY
RETURN FOR
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34688

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A TUBES LIMITED

ley Road, Redditch, Worcestershire B98 7HN, England
phone (01527) 484500, Facsimile (01527) 484501

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ner

AEROSPACE LIMITED
BERDEEN STREET
ESBURY
O
A
7

Your Order No

PO00004611

Your Part No

D6008-180P

Our Order No

94945/6

Packing Note No

151438

Date

30/11/07

Packages

1 CASE

Other Tests Passed

escription
ESS DRAWN TUBE 3.250 INS O/D .438 INS W/T 7075 Alloy
- 100.00 inches

Specification

7075 T6
WW-T-700/7B


No. C/151438/1

Nett Weight Lbs	Tensile Test					Chemical Analysis %														H cc/ 100 gm
	Test No	0.2% Proof Stress KSI	Tensile Strength KSI	% Elongation 2in		Heat or Cast No	Si	Fe	Cu	Mn	Mg	Cr	Ni	Zn	Zr			Ti		
569	331215 LO	68.9	79.0	14		2N268	.07	.29	1.41	.03	2.39	.21	.01	5.79	.01			.03	.13	

CASE NO.12977

ALLOY MELTED IN THE UNITED KINGDOM

Inspection Representative


Layton For and on behalf of BA Tubes

England No. 3981396
Office: The Victoria, 150-182 Harbour City
rs, Salford, M50 3BP, England.
ation No. 68 668 2142 26

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These results pertain only to the item(s) tested as samples by the client unless otherwise indicated.